

**Amendments to the Specification:**

Please replace Table 2 on page 29 with the following table:

Sample No.	Coating layer *								Cooling rate (°C./min.)	F <sub>L</sub> /F <sub>U</sub>	Observation in cross-sectional direction		Observation in surface direction	
	Base layer	TiCN layer			Middle layer	Al <sub>2</sub> O <sub>3</sub> layer	Surface layer	TiCN particle			Aspect ratio	TiCN particle	Aspect ratio	
		First layer	Second layer	Third layer										
I - 1	TiN (0.5) →	TiCN1<G> (6.0)[0.3] →	TiCN4<G> (3.0)[1.0] 140N(F <sub>L</sub> )	-	TiCNO (0.5) →	α-Al <sub>2</sub> O <sub>3</sub> (2.0) 45N(F <sub>L</sub> )	TiN (0.2) <5N		20	3.1	Column	13	Acicular	5
I - 2	TiN (0.6) →	TiCN1<G> (3.0)[0.3] →	TiN (0.5) (0.5)	TiCN4<G> (0.8)[1.0] 80N(F <sub>L</sub> )	TiCO (1) →	α-Al <sub>2</sub> O <sub>3</sub> (4.0) 70N(F <sub>L</sub> )	TiN (0.5) <5N		20	1.14	Column	10	Acicular	6
I - 3	TiN (1) →	TiCN1<G> (3.0)[0.3] →	TiCN3<G> (2.0)[0.9] 150N(F <sub>L</sub> )	-	TiNO (0.3) →	α, κ-Al <sub>2</sub> O <sub>3</sub> (2.0) 10N(F <sub>L</sub> )	TiN (1) <5N		15	15.0	Column	14	Acicular	6
I - 4	Nothing	TiCN<g> (0.5)[-] →	TiCN1<G> (3.0)[0.5] →	TiCN3<G> (4.0)[0.9] 80N(F <sub>L</sub> )	TiCNO (0.1) →	α, κ-Al <sub>2</sub> O <sub>3</sub> (5.0) 35N(F <sub>L</sub> )	Nothing		25	2.3	Column	8	Acicular	3
I - 5	TiN (0.6) →	TiCN1<G> (4.0)[0.3] →	TiCN3<G> (3.0)[0.8] 150N(F <sub>L</sub> )	-	TiCNO (0.3) →	κ-Al <sub>2</sub> O <sub>3</sub> (2.0) 25N(F <sub>L</sub> )	TiN (1) <5N		15	6.0	Column	7	Acicular	5
I - 6	Nothing	TiCN2<G> (1.0)[0.3] →	TiCN3<G> (4.0)[0.9] →	TiCN4<G> (2.0)[1.0] 65N(F <sub>L</sub> )	TiCO (1) →	α-Al <sub>2</sub> O <sub>3</sub> (4.0) 50N(F <sub>L</sub> )	TiN (0.5) <5N		25	1.3	Column	8	Acicular	4
I - 7	TiN (0.6) →	TiCN3<G> (0.3)[0.8] →	TiCN3<G> (3.0)[0.8] →	-	TiCNO (1.5) →	α-Al <sub>2</sub> O <sub>3</sub> (5.0) 80N(F <sub>L</sub> , F <sub>U</sub> )	Nothing		10	1.0	Column	3	Isotropic	1.2
I - 8	Nothing	TiCN3<G> (0.3)[0.8] →	TiCN2<G> (3.0)[0.4] 33N(F <sub>L</sub> )	-	TiCNO (0.5) →	α-Al <sub>2</sub> O <sub>3</sub> (3.0) 32N(F <sub>L</sub> )	TiN (0.2) <5N		20	1.03	Column	6	Isotropic	1.5
I - 9	TiN (0.6) →	TiCN1<G> (7.0)[0.3] 100N(F <sub>L</sub> )	-	-	-	κ-Al <sub>2</sub> O <sub>3</sub> (7.0) →	TiN (0.2) 3N(F <sub>U</sub> )		40	33.0	Column	20	Acicular	8
I - 10	Nothing	TiCN5<G> (6.0)[0.5] 145N(F <sub>L</sub> )	-	-	TiCNO (0.1) →	α-Al <sub>2</sub> O <sub>3</sub> (10.0) 5N(F <sub>L</sub> )	TiN (0.2) 3N(F <sub>L</sub> )		20	29.0	Column	10	Acicular	4

\*( ) represents layer thickness and [ ] represents a mean crystal width. Unit: μm

TiCN&lt;g&gt; and TiCN&lt;p&gt; respectively represent columnar TiCN and particulate TiCN.

The peeling load (N) of each layer is shown at the bottom of each coating layer. '→' means that the layer peels together with a layer on it.

Please replace Table 3 on page 31 with the following table:

Sample No.	Wear resistance test: wear amount (mm)		Fracture resistance test Number of impacts before fracture (times)	Condition of hard coating layer
	Flank wear	Wear at the tip		
I- 1	0.14	0.13	5000	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 2	0.22	0.20	4300	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 3	0.20	0.18	4000	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 4	0.12	0.11	4700	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 5	0.19	0.17	4500	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 6	0.17	0.16	4700	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 7	0.35	0.32	1100	Large chipping (Exposure of base material)
I- 8	0.40	0.41	2500	Large chipping (Exposure of base material)
I- 9	0.43	0.40	1700	Peeling of Al <sub>2</sub> O <sub>3</sub> layer
I- 10	0.23	0.22	4000	Minute peeling of Al <sub>2</sub> O <sub>3</sub> layer